

Gun Drill Production Ø10 Z1

A06-500

Complete production of gun drill with cylindrical grinding to final diameter, flute face and back, all end angles and the circumferential chamfer in a single clamping.

A guided gun drill support for outside of the machine is available as an option, as shown on the right.



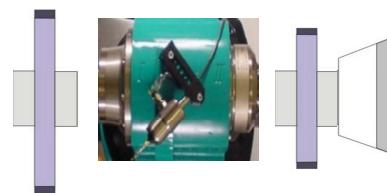
1. Cycletime for Production

Workpiece:	Diameter 10 mm, Z 1, Length of cutting edge 35 mm, Helix angle 0° Material CARBIDE								
Operations	Probe	Cylindrical	Flute front	Flute back	End 1	End 2	End 3	End 4	Chamfer
Feed [mm/Min]	2000	200	100	100	120	120	120	120	90
Power [kW]		1	1	1	1	1	1	1	1
Cutting speed [m/s]		20	20	20	20	20	20	20	20
Used wheels		1	2	2	3	4	4	4	4
Grinding time [s]	10	251	34	34	18	18	19	19	27
Total cycle time	7 Min 9								

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø150 D46
2	1A1 Ø75 D64
3	11V9 Ø100 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : normaNGC

Control: Fanuc 3x

Accessories:

Responsible engineer: SEA, 21.11.18

Coolant: Synthetic Oil, pressure 8 bar

Software: Quinto Qg1

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